

Liu et al.  
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**In the Claims:**

1. **(Previously Presented)** A method of extruding structural members comprising:
  - (a) providing an alloy consisting essentially of:
    - about 3.6 to about 4.2 wt % copper,
    - about 1.0 to about 1.6 wt % magnesium,
    - about 0.3 to about 0.8 wt. % manganese,
    - about 0.05 to about 0.25 wt. % zirconium,
    - not more than about 0.08 wt.% iron,
    - not more than about 0.06 wt.% silicon
  - the balance substantially aluminum, incidental elements, and impurities;
  - (b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;
  - (c) solution heat treating said extrusion; andquenching said extrusion before making a structural member therefrom.
2. **(Previously Presented)** The method of claim 1 wherein the extrusion billet temperature in step (b) is about 550° to about 650°F.
3. **(Previously Presented)** The method of claim 1 wherein the extrusion billet temperature in step (b) is about 600° to about 650°F.
4. **(Currently Amended)** The method of claim 1 which further includes:
  - (e) (d) stretching said extrusion by at least about 1 %.
5. **(Withdrawn)** The method of claim 27 which further includes:
  - (e) stretching said extrusion between about 1 to about 10%.
6. **(Withdrawn)** The method of claim 27 which further includes:
  - (e) stretching said extrusion between about 1 to about 8%.

Liu et al.  
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7. **(Withdrawn)** The method of claim 27 which further includes:  
(e) stretching said extrusion between about 1 to about 3%.
8. **(Withdrawn)** The method of claim 27 which further includes:  
(e) stretching said extrusion by at least about 1 %, said extrusion  
having less than about 50% by volume recrystallized after stretching.
9. **(Withdrawn)** The method of claim 27 which further includes in  
step (e):  
(e) stretching said extrusion by at least about 1 %, said extrusion  
being substantially unrecrystallized.
10. **(Withdrawn)** The method of claim 27 which further includes in  
step (e):  
(e) stretching said extrusion by at least about 1 %, said extrusion  
having a longitudinal yield strength of at least about 50 ksi and a  
longitudinal tensile ultimate strength of at least about 70 ksi.

#### Claims 11-26 Cancelled

27. **(Withdrawn)** A method of extruding structural members consisting  
essentially of:  
(a) providing an alloy consisting essentially of:  
about 3.6 to about 4.2 wt % copper,  
about 1.0 to about 1.6 wt. % magnesium,  
about 0.3 to about 0.8 wt % manganese,  
about 0.05 to about 0.25 wt.% zirconium,  
not more than about 0.08 wt.% iron,  
not more than about 0.06 wt.% silicon,

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the balance substantially aluminum, incidental elements, and impurities;

- (b) extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;
- (c) solution heat treating said extrusion;
- (d) quenching said extrusion before making a structural member therefrom; and
- (e) stretching said extrusion by at least about 1 %.

28. **(Previously Presented)** A method of extruding structural members having a combination of high strength and toughness, said method comprising:

- (a) providing an alloy consisting essentially of:
  - about 3.6 to about 4.2 wt. % copper,
  - about 1.0 to about 1.6 wt. % magnesium,
  - about 0.3 to about 0.8 wt. % manganese,
  - about 0.05 to about 0.25 wt.% zirconium,
  - not more than about 0.08 wt.% iron,
  - not more than about 0.06 wt.% silicon,
  - the balance substantially aluminum, incidental elements, and impurities;
- (b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;
- (c) solution heat treating said extrusion; and
- (d) quenching said extrusion before making a structural member therefrom.